

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010953**Date Inspected:** 01-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SAW welding of weld joint WSTL4-2B/L-60A located outside PCMK west tower, lift 4, skin A to skin E, between approximately 122M and 127M elevations. Welder was identified as 047304. ZPMC QC was identified as CWI Li Lin (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

SAW welding of weld joint WSTL4-2B/L-60A located outside PCMK west tower, lift 4, skin A to skin E, between approximately 127M and 132M elevations. Welder was identified as 042195. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

SAW welding of weld joint WSTL4-2B/L-60A located outside PCMK west tower, lift 4, skin A to skin E, between approximately 132M and 136M elevations. Welder was identified as 202756. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also

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present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

Blast Shop #1

This QA Inspector and Caltrans QA Inspector Paul Dawson performed random visual inspections of the upper interior areas from the west end of OBG Segment 8BW to panel point 65 and panel point 65 to panel point 66 as per ZPMC request number 2413, Document No. PR008, Rev. 03. ZPMC had recently completed grit blasting of these areas and the steel surfaces are now mostly free of rust oxide and other contaminants that had previously obscured portions of the plate and weld surfaces. This QA Inspector visually observed approximately 60 locations that required grinding to resolve visual weld spatter, arc strikes, shallow nicks, scrapes, and other minor surface rejections. The areas were marked with colored chalk and ZPMC had several workers using grinders to remove the visually unacceptable areas and ZPMC had assigned a magnetic particle test (MT) inspector to perform MT of the arc strike removal areas. Three welds were also observed to be incomplete. These areas were marked for weld repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Dawson, Paul	QA Reviewer
